

Date: Thursday, 11/15/2007 1:20:22 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEG
Job Number : 35752	
Estimate Number : 12907	
P.O. Number : <i>N/A</i>	Part Number : D35233
This Issue : 11/15/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3523 REV B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 11/15/2007 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35168	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/22/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>12</i> Um: Each
Comment : Est Rev: A New Issue 07-06.15 EC	
Est Rev: B Added Helicoil 07-07-19 JLM	Verified by: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1218 f(s)/Unit Total : 0.9744 f(s)
6061-T6 round bar 1.00"
(M6061T6 round bar 1.00")
Batch: *M104554*

USE D35233
07-11-28

07-11-28 *(12)*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA702 & dwg D3523

07-11-28 *(12)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07-11-28 *(12)*

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Drill For Helicoil & Set-Screw

07-12-02 *(12)*

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07-12-02 *(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.12.03 (X12)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FL 07/12/05 (X12)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

-Mask threaded holes & Ball as per Dwg D3523

-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

E N/A

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SA 07/12/12 (X12)

10.0 MS21209F120 HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELI COIL

Batch: M104996

B. A / ml
07/12/14

11.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg D3523

B. A / ml
07/12/14

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/12/14 (X12)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 11007

7/12/17 50 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

2007/12/18

Job Completion



Kim 2007/12/17

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

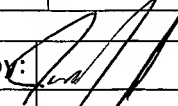
NOTE: Date & initial all entries

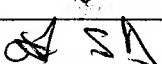
DART AEROSPACE LTD		Work Order:	32752
Description: Leg		Part Number:	D3523-3
Inspection Dwg: D3523 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

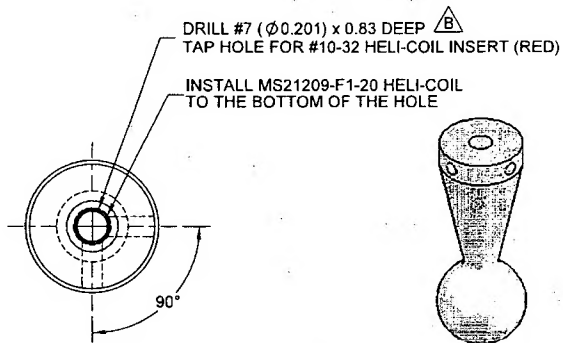
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.700	+0.008/-0.001	Ø.702	✓			
R0.13	+/-0.030	R.125	✓			
Ø0.742	+0.000/-0.010	Ø.740	✓			
0.350	+/-0.010	.353	✓			
0.374	+/-0.010	.374	✓			
0.200	+/-0.010	.203	✓			
1.140	+/-0.010	1.137	✓			
90°	+/-0.5°	90°	✓			
(2) 6-40 UNF	N/A	6-40 UNF	✓			
0.83 deep	+/-0.030	.83	✓			
Tap 10-32 Heli-Coil	N/A	10-32	✓			
0.100	+/-0.010	.101	✓			

Measured by:	
Date:	

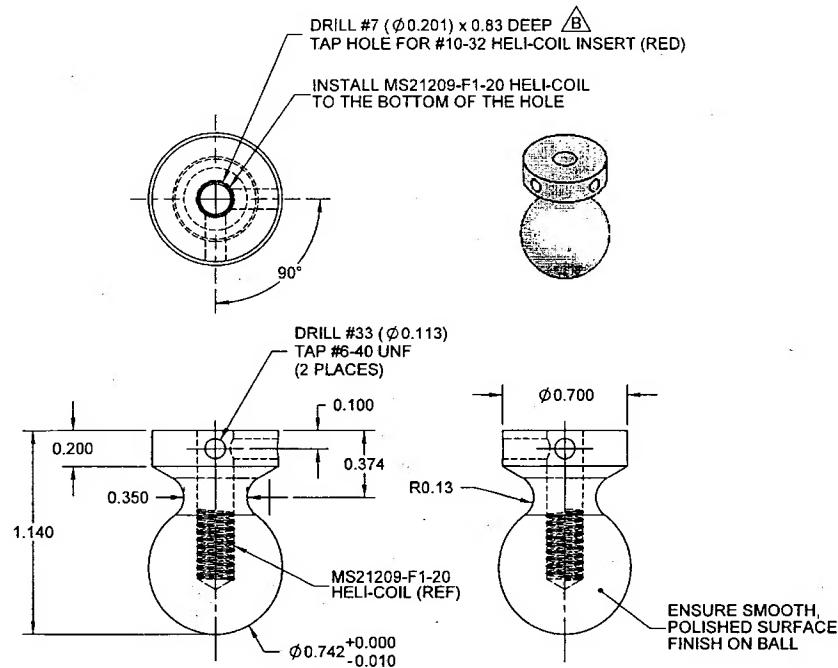
Audited by:	
Date:	07.12.03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD 	



D3523-1 LEG



D3523-3 LEG

RELEASED
07.08.03 #



NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3523-1: 0.05 lbs
D3523-3: 0.03 lbs

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32752

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES; ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	BE	D3523	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	#	LEG	3:2
DATE	07.07.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	